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D3200-3**Job Sheet 194886****Part No:** D3200-3**Job Qty:** 20 pcs**Part Name:** Door Wedge**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/9/19**Job Tracking No:****Due Date:** 6/24/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	6/24/19	6/24/19	0.00	0.66	Bandsaw - 1	DAS 52 9-89	19/05/31
110	HAAS 4 Axis - B4B	20 pcs	6/24/19	6/24/19	0.07	4.55	HAAS - 1 - B4B	DAS 52 9-89	19/05/31
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs	6/24/19	6/24/19	0.00	0.00	QC 8 - 12	DAS 52 9-89	19/06/05
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	20 pcs	6/24/19	6/24/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

**Container No:** S186136**Part:** D3200-3**Job No:** 194886**Serial No/Batch:** S186136**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 05/31/19

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 51022
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	20 pcs	6/24/19	0.00 0.00	QC 21 - SA - 21	DAC 21 9-86
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blank: 1.000 X 1.970"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3200-3 as per Folio FA337 and Dwg D3200

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

JUN 06 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	.3000 sf (.015 ea)	100-Bandsaw - 1	4136453

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MUHMWB10	0	1,025	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Wedge	0.196inches + 0.005 - 0.000	0.201 0.196	0.196	
2	Door Wedge	0.405inches ± 0.010	0.415 0.395	0.405	
3	Door Wedge	100.000Degrees ± 0.000	100.000 100.000	100°	
4	Door Wedge	0.500inches ± 0.010	0.510 0.490	0.500	
5	Door Wedge	1.722inches ± 0.010	1.732 1.712	1.722	
6	Door Wedge	0.380inches ± 0.010	0.390 0.370	0.380	
7	Door Wedge	0.750inches ± 0.030	0.780 0.720	0.751	
8	Door Wedge	0.015inches + 0.050 - 0.000	0.065 0.015	0.055	

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DAS
52
9-89

19/05/31

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					